



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB6796941-201-3
Job Sheet 169589



Part No: RB6796941-201-3

Job Qty: 3 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/14/17

Job Tracking No:

Due Date: 12/15/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB6796941-201 Rev2 IPP Rev A 17.12.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		12/14/17	0.00	0.00	Start Up Machining-3		17-12-17
110	Mori Seiki	3 pcs		12/15/17	0.00	1.00	MORI SL-154		17-12-17
120	QC	3 pcs		12/15/17	0.00	0.00	QC2 Machining-4		17-12-17
130	QC	3 pcs		12/15/17	0.00	0.00	QC8 Machining-4		17-12-17
140	QC	3 pcs		12/15/17	0.00	0.00	QC5		17-12-17
150	Outsource	3 pcs		12/15/17			GRO002-VC	10	17-12-17
151	Packaging	3 pcs		12/15/17	0.00	0.00	Packaging2		17-12-17
152	QC	3 pcs		12/15/17	0.00	0.00	QC6		17-12-17
153	Packaging	3 pcs		12/15/17	0.00	0.00	Packaging3-2		17-12-17
190	QC21-SA	3 Ea		12/15/17	0.00	0.00	QC21		17-12-17

Part Op 110 - 1-Machine as per folio FB 701 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 150 - -Issue P/O to Groupe Altech; PO 38684 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required

DEC 19 2017

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9-89

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MT-1144-R0.625	0	10	0	0
	FF000024 138293	1.15			

Part Specifications

Specifications could not be found.

Plex 12/14/17 9:33 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	
		Completed By	
		Lead hand / Supervisor Approval Verification	

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
			OTHER : ☐

Job No: 169589
Mfg Date: 12/17/17

Start up Operation
RB6796941-201-3

Change No:
Operation:
Revision:
PART NO:



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



DART AEROSPACE LTD		Work Order:	169589
Description: plug		Part Number:	886796941-201-3
Inspection Dwg:	Rev: 2		Page 1 of 1

INSPECTION SHEET

[illegible]

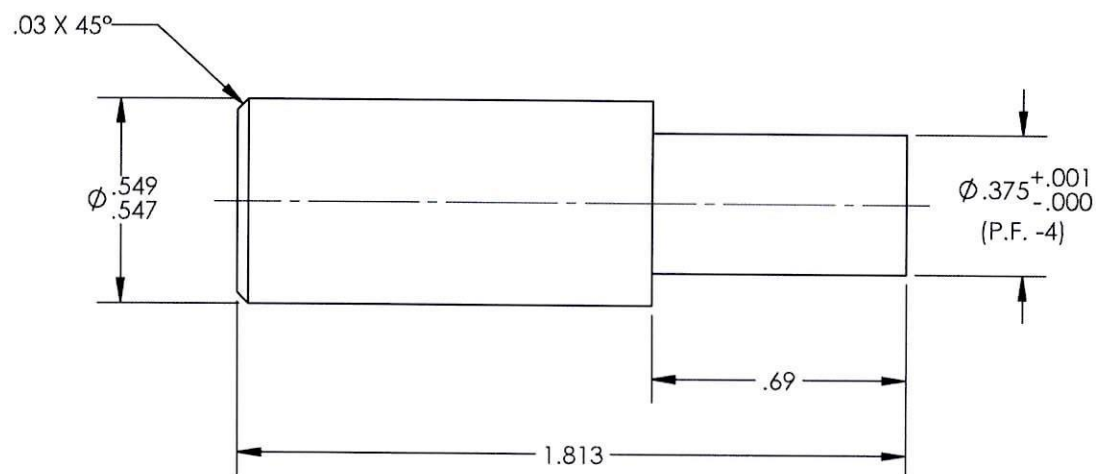
Measured by:	<i>Sh</i>	Checked by:	<i>FK</i>	QC Inspector:	
Date:	<i>17-12-17</i>	Date:	<i>17-12-17</i>	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0082	-3 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	4/7/2017	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 169436 hcs
17-12-11

(-3)
PLUG

DART AEROSPACE	
TITLE STARTER PULLER ASSY.	
DWG NO. RB6796941-201-3	REV 2
MAT'L STRESSPROOF	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: COLE	.X ± .1 SURFACES = 125/
CHECKED: DD 04/07/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 04/10/2017	.015 x 45° OR .015R
QA APPR: JL 04/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 04/13/2017	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER
DATE 7/17/2000	ASME Y14.5M-2009
SHEET 2 OF 3	USED ON MODEL
	SEE NOTE 1, SHEET 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038684**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038684
PO Date: 12/19/17
Due Date: 1/3/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

E-MAILED

DEC 20 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	168797	RBW6505G00831-3G-7	Swivel Plate Weldment -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow - Certificate of Conformity is required	Firmed	1/3/18	1 pcs	0 pcs	1 pcs	\$58.3333/pcs	\$58.33
2	168796	RBW6505G00831-3G-1	Leg Assembly Weldment -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow - Certificate of Conformity is required	Firmed	1/3/18	1 pcs	0 pcs	1 pcs	\$58.3333/pcs	\$58.33
3	169248	RBW6505G00831-3G-21	Swivel Plate -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-416F TYPE II, CLASS II -Color; Yellow - Certificate of Conformity is required	Firmed	1/3/18	1 pcs	0 pcs	1 pcs	\$58.3333/pcs	\$58.33
4	169589	RB6796941-201-3	Plug -Issue P/O to Groupe Altech: PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	1/3/18	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00

6x SP18-D110

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2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Certificat de Conformité / Certificate of Compliance



Bon de Livraison / Packing Slip

005425- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courtier / Acc. No.	Bon de commande Client Customer Purchase Order No.
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08-Jan-2018

Ross Montieth

038684

#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6505G00831-3G-7 Rev.	SWIVEL PLATE WELDMENT 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416, TYPE II, CLASS II: CADMIUM YELLOW ***	CADMIUM CH	1	1	0	0	0
2	RBW6505G00831-3G-1 Rev.	LEG ASSEMBLY WELDMENT 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416, TYPE II, CLASS II: CADMIUM YELLOW ***	CADMIUM CH	1	1	0	0	0
3	RBW6505G00831-3G-21 Rev.	SWIVEL PLATE 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416, TYPE II, CLASS II: CADMIUM YELLOW ***	CADMIUM CH	1	1	0	0	0
4	RB6796941-201-3 Rev.	PLUG BLACK OXIDE MIL-C-13924C CLASS 1	BLACK-OXIDE CH	6	5	0	0	0
5	647.8510 Rev.	647.8510 PASSIVATE ,MIL-S-5002 TYPE 6	PASSIVATION CH	80	80	0	0	0

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8/18-01-10

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements
 Our financial and legal responsibility will not be higher than the amount of invoice.

DART
AEROSPACE
S030913



Plug

PART NO: RB6796941 – 201 – 3
Revision:
Operation: Outsource
Change No:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632 – 5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 01/10/18
Job No: 169589

1/18/2018

Print



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: MT1144R0.750 Revision: 1144 Steel Proof Round Bar 0.750"														
100	Receive Ft	S023928	169589	0 ft	0	M138293	Start Up Machining-3		Stock	12/17/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Part Number: RB6796941-201-3 Revision: Plug														
190	QC21-SA	S030913	169589	6 Ea	0	S030913	QC21		Stock	1/10/2018	Issue Container			
Operation Totals:		1		6	0									
Part Totals:		1		6	0									
Totals:		2		6	0									

Plex 1/18/2018 9:20 AM dart.Gagnon.Michelle